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FIG. 1

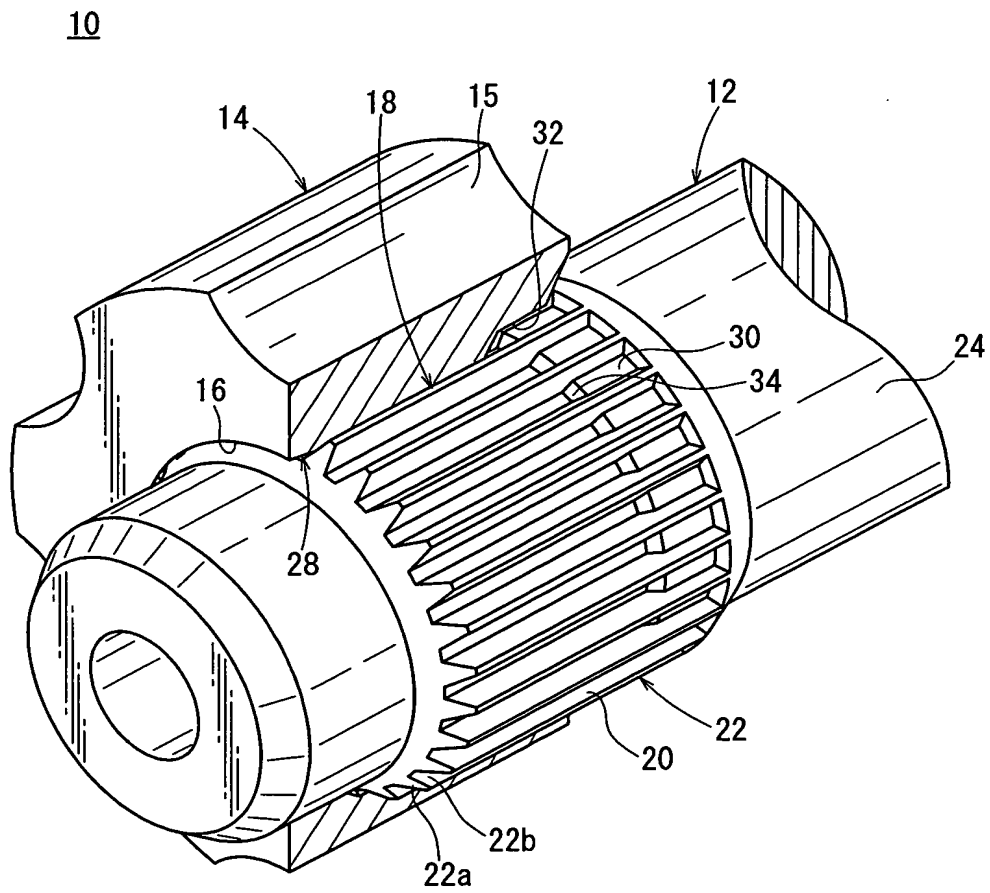
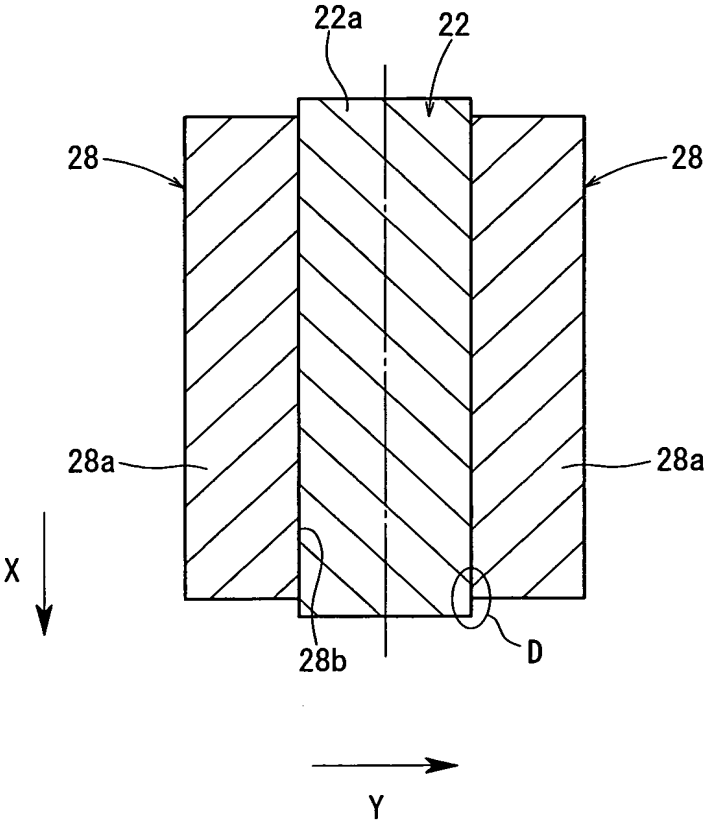
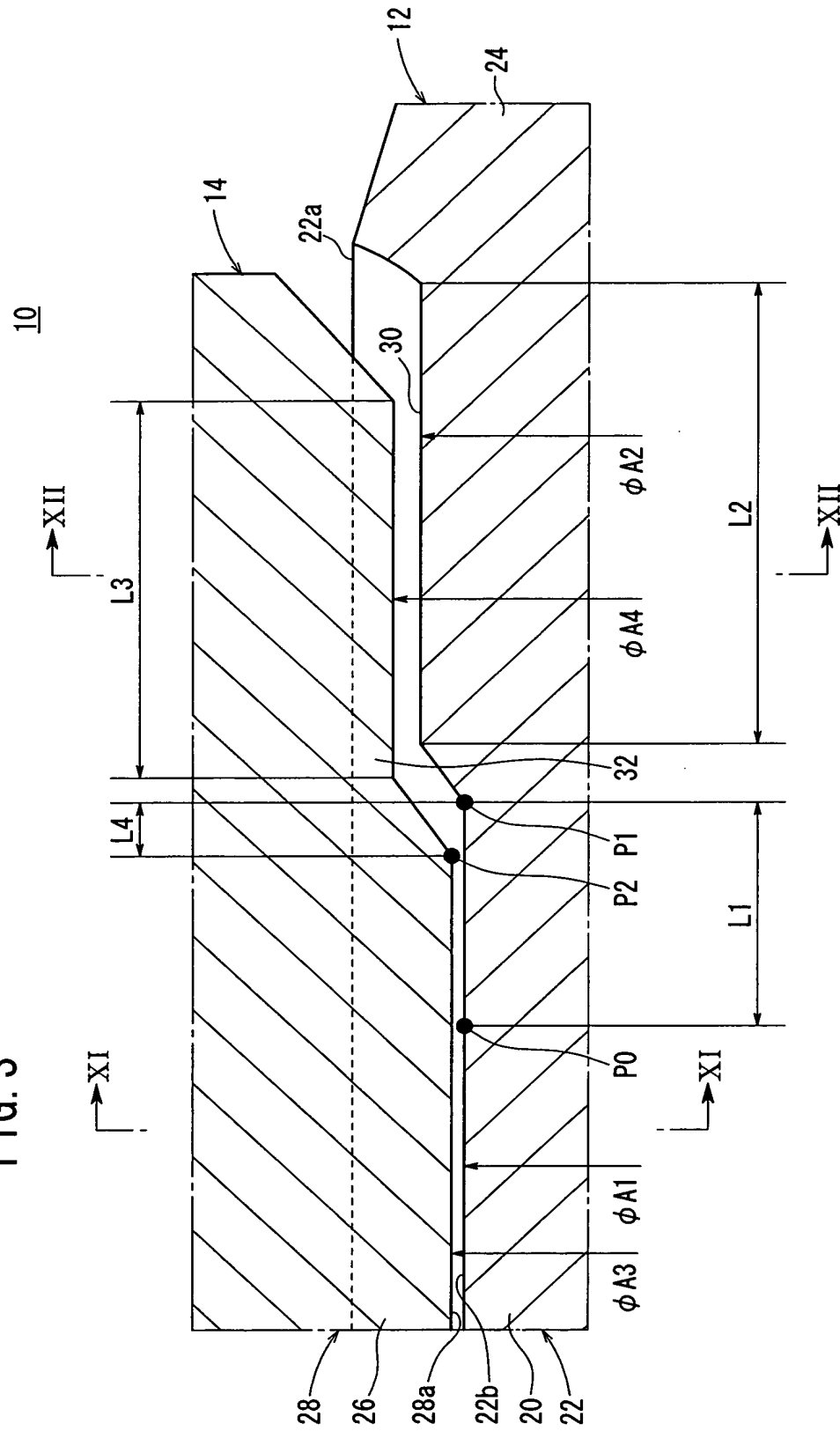


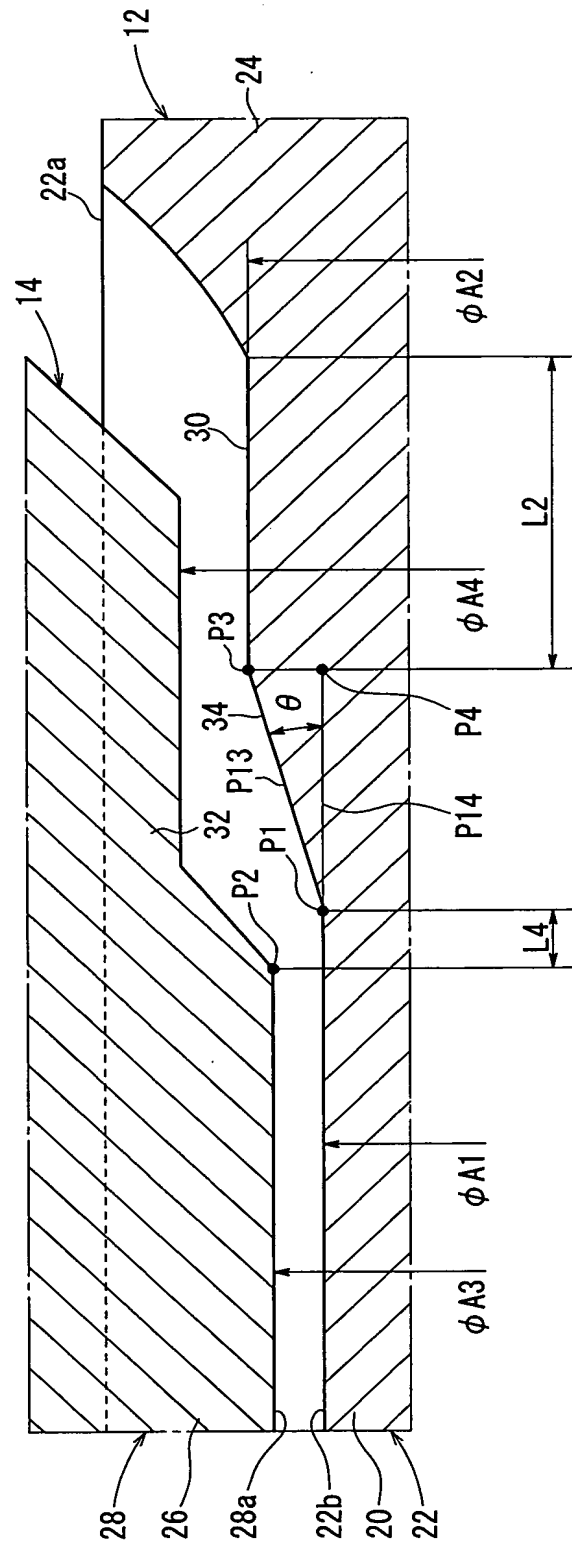
FIG. 2



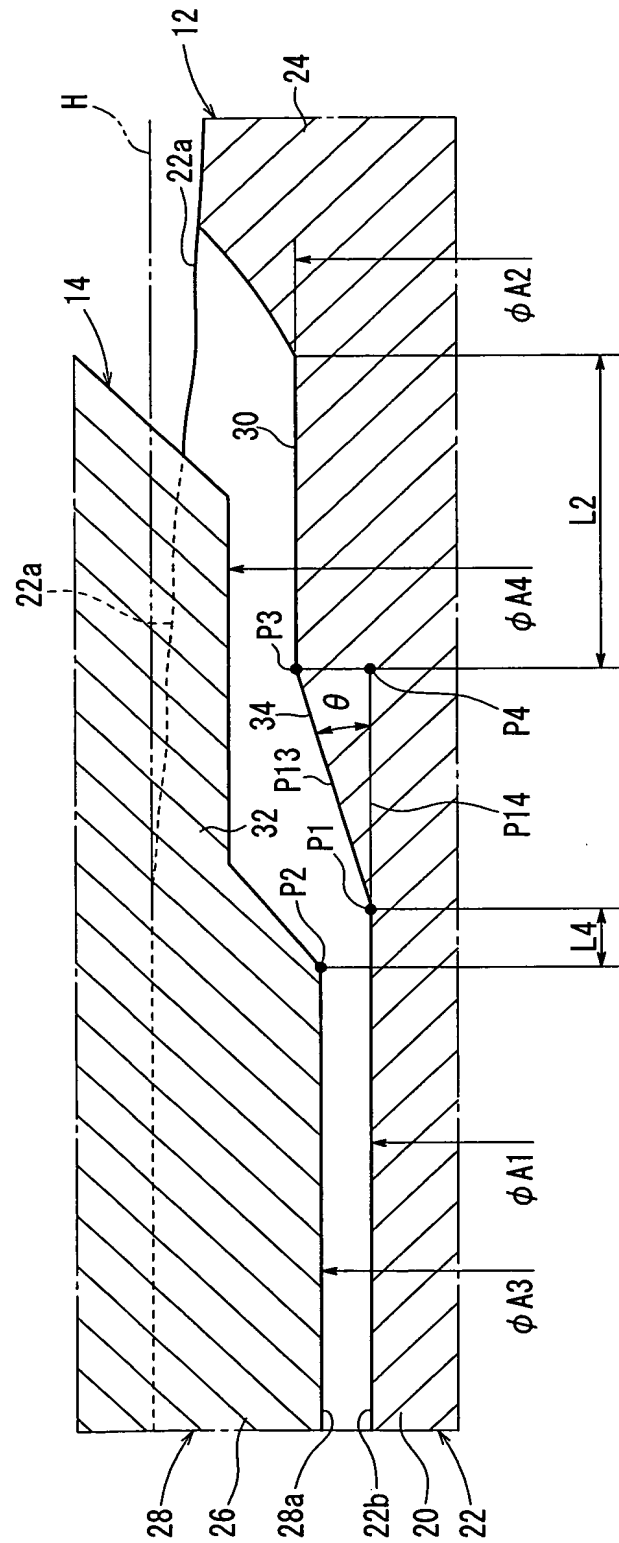
**FIG. 3**



**FIG. 4**



**FIG. 5**

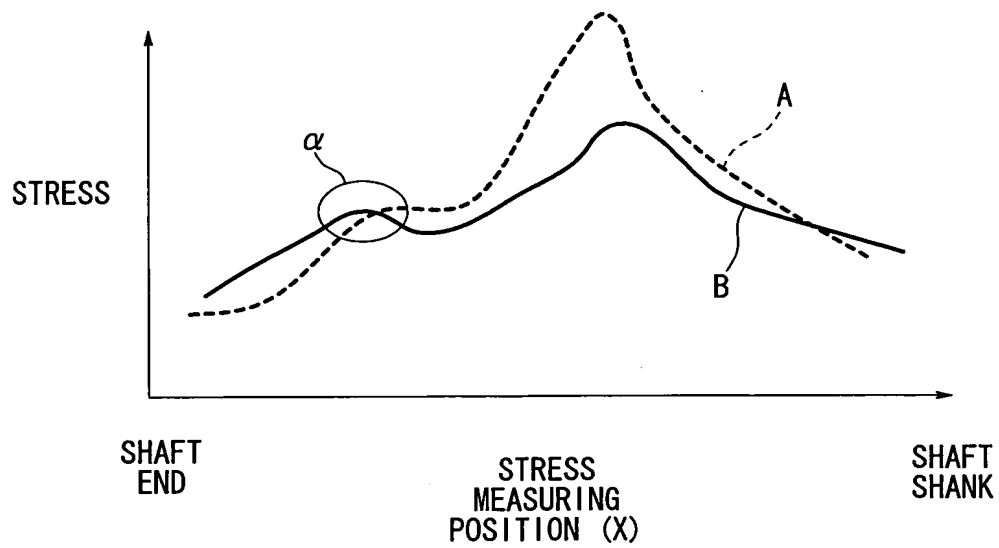


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FIG. 6

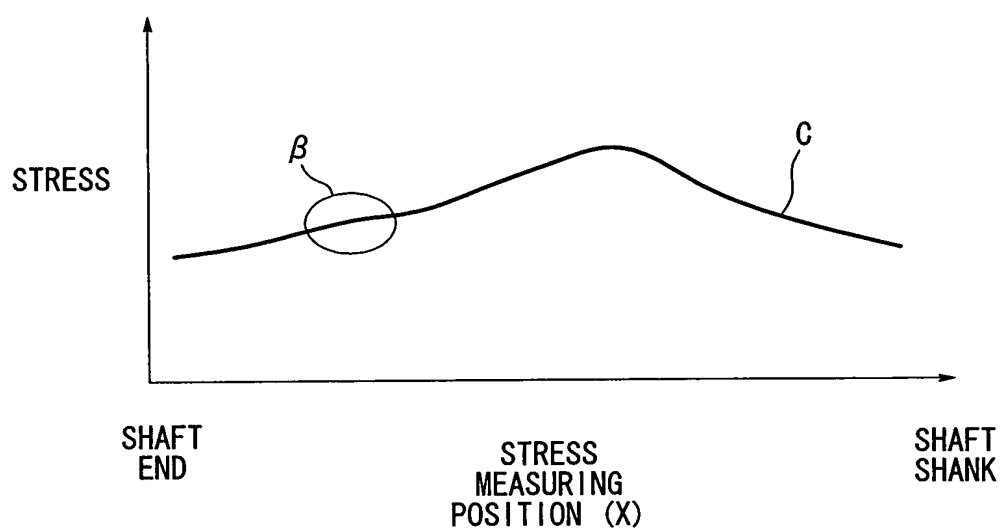
| TILT ANGLE $\theta$ | 3° | 5° | 10° | 15° | 25° | 35° | 45° | 90° |
|---------------------|----|----|-----|-----|-----|-----|-----|-----|
| STRESS RELAXATION   | ×  | ○  | ◎   | ◎   | ◎   | ◎   | ○   | ×   |
| PRODUCTIVITY        | ×  | ○  | ◎   | ◎   | ◎   | ◎   | ○   | ×   |

FIG. 7



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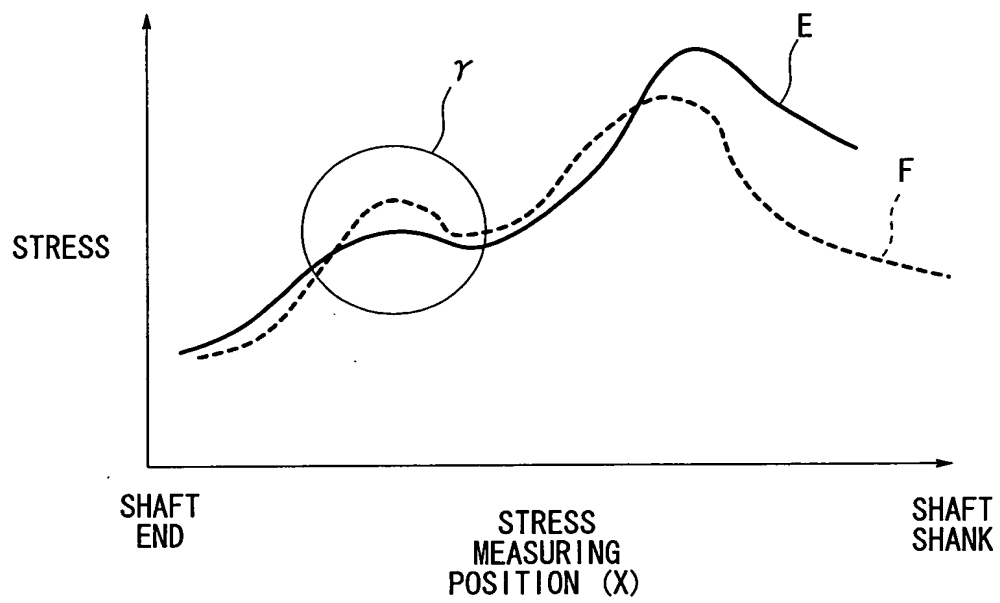
FIG. 8





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FIG. 9



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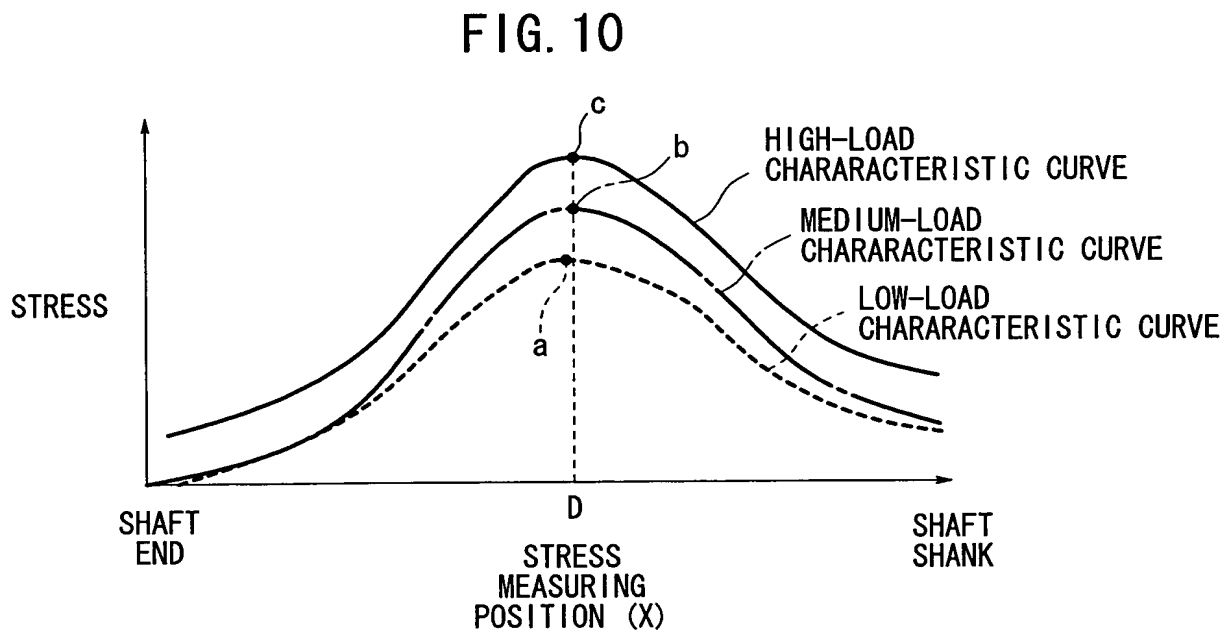


FIG. 11

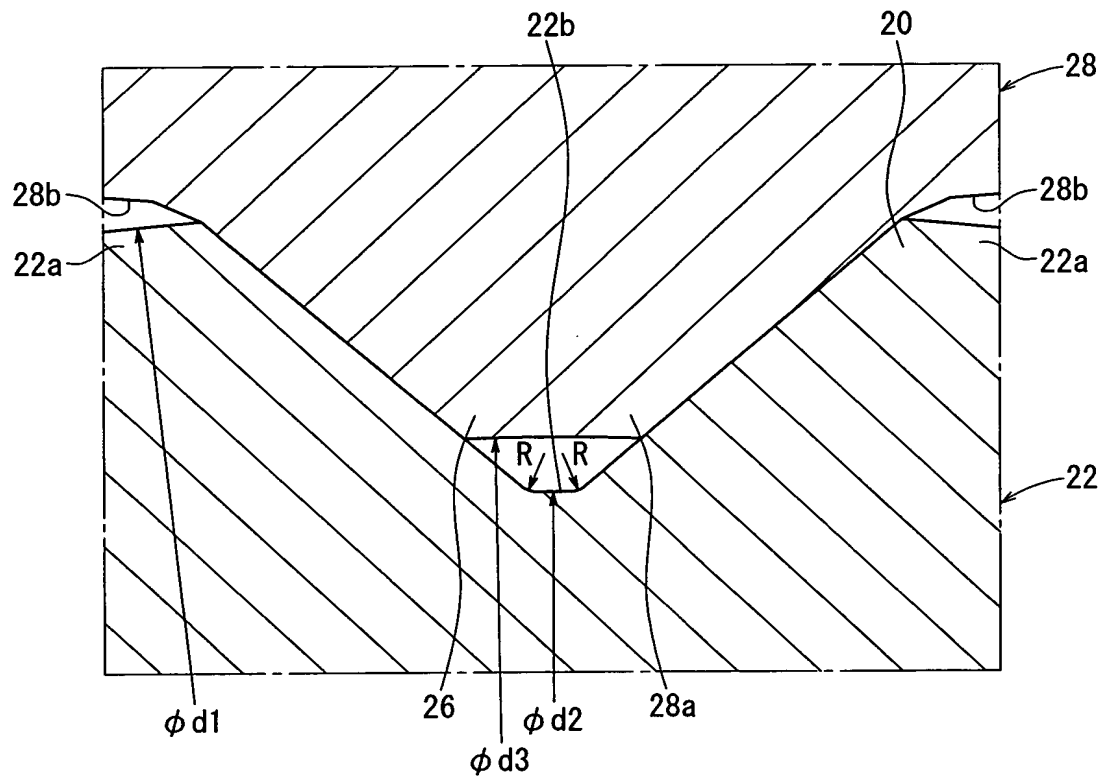


FIG. 12

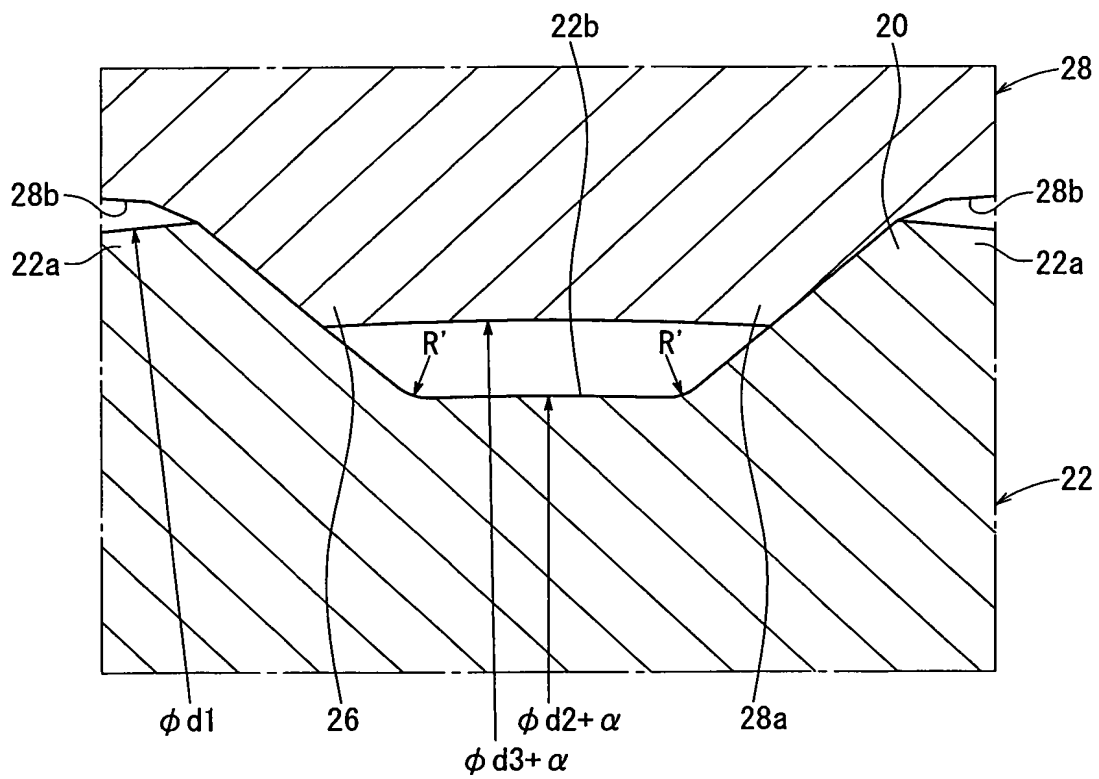
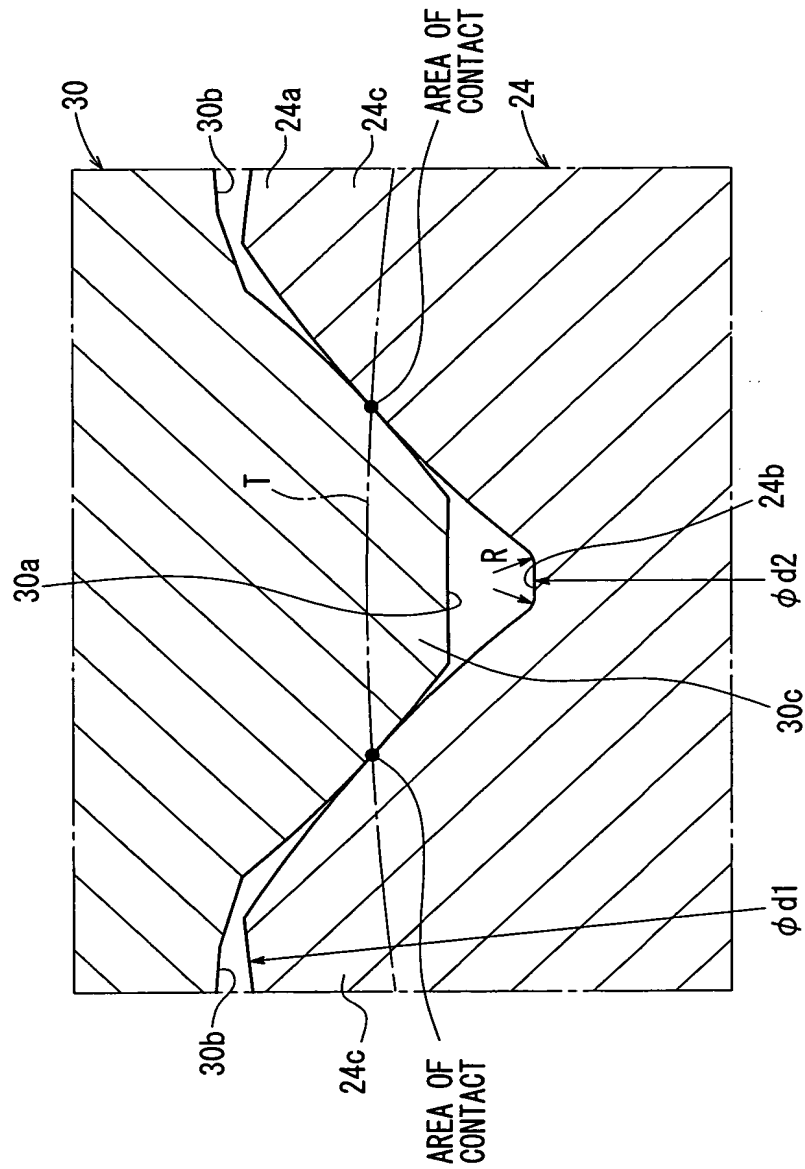
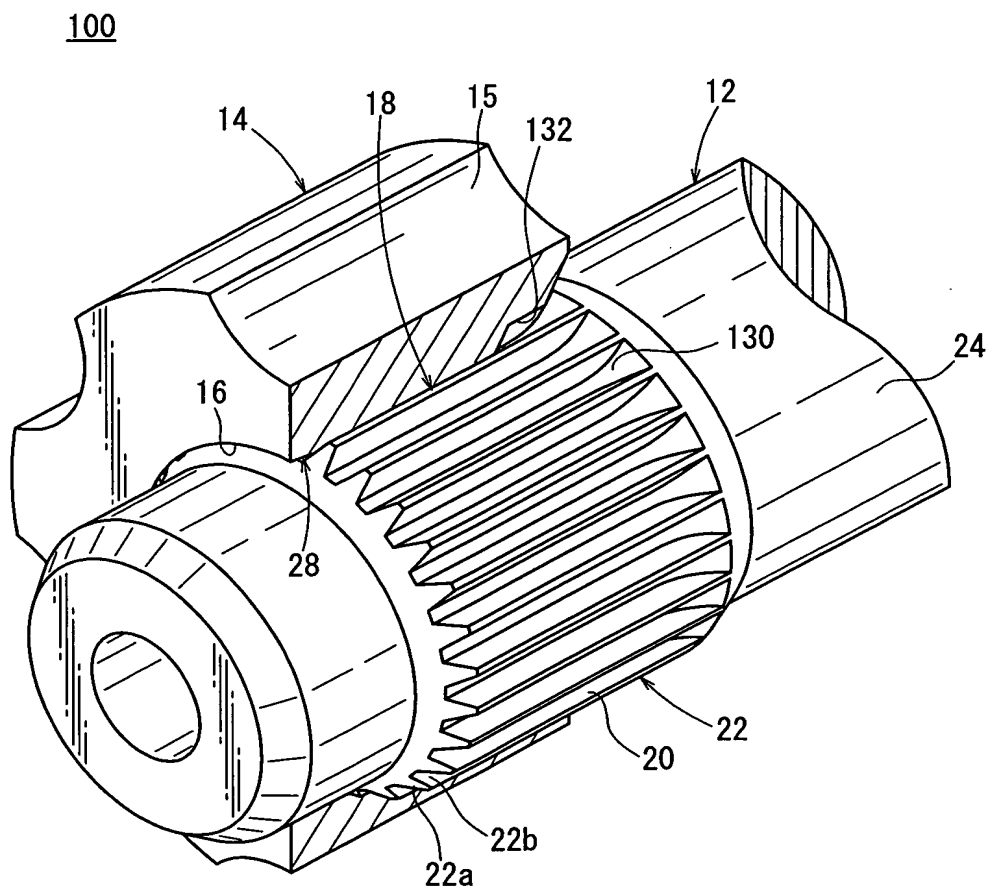


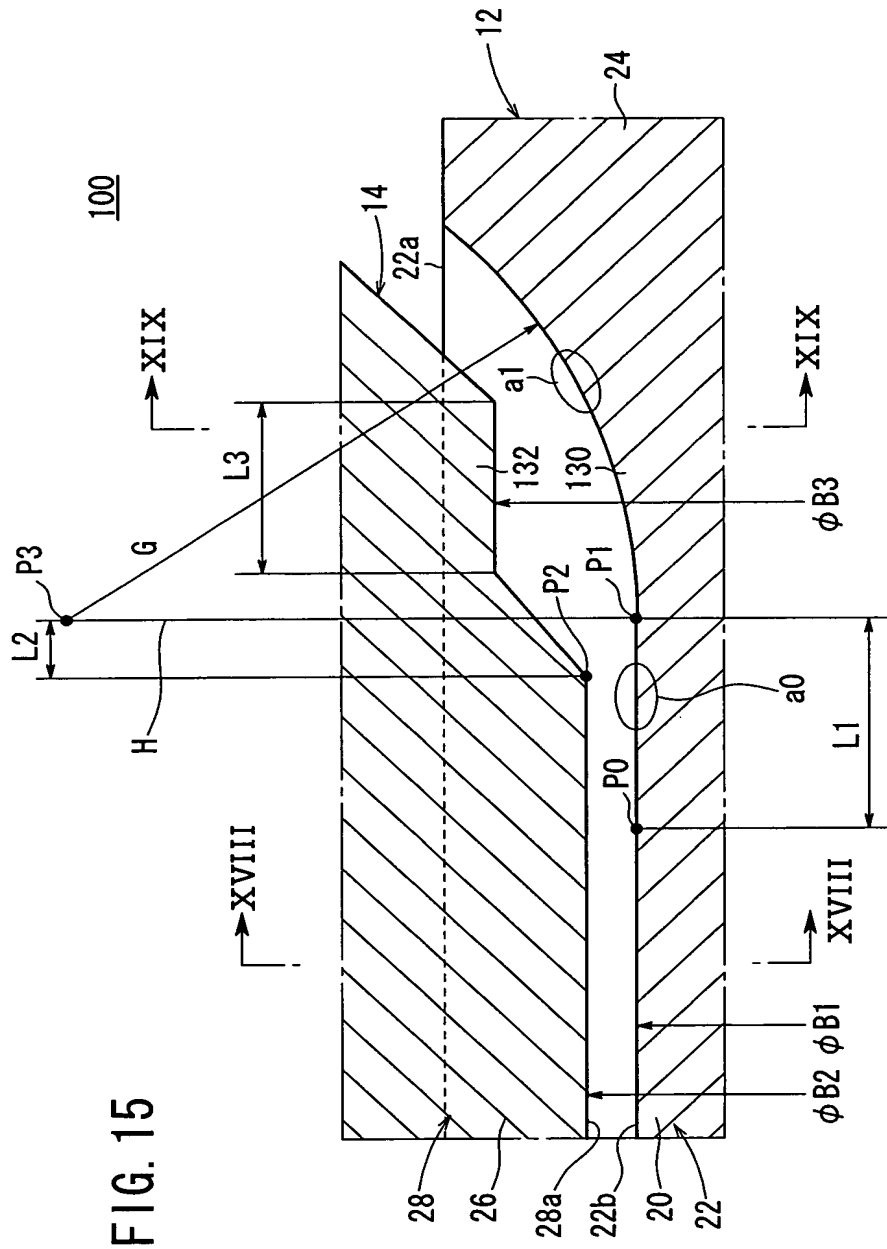
FIG. 13

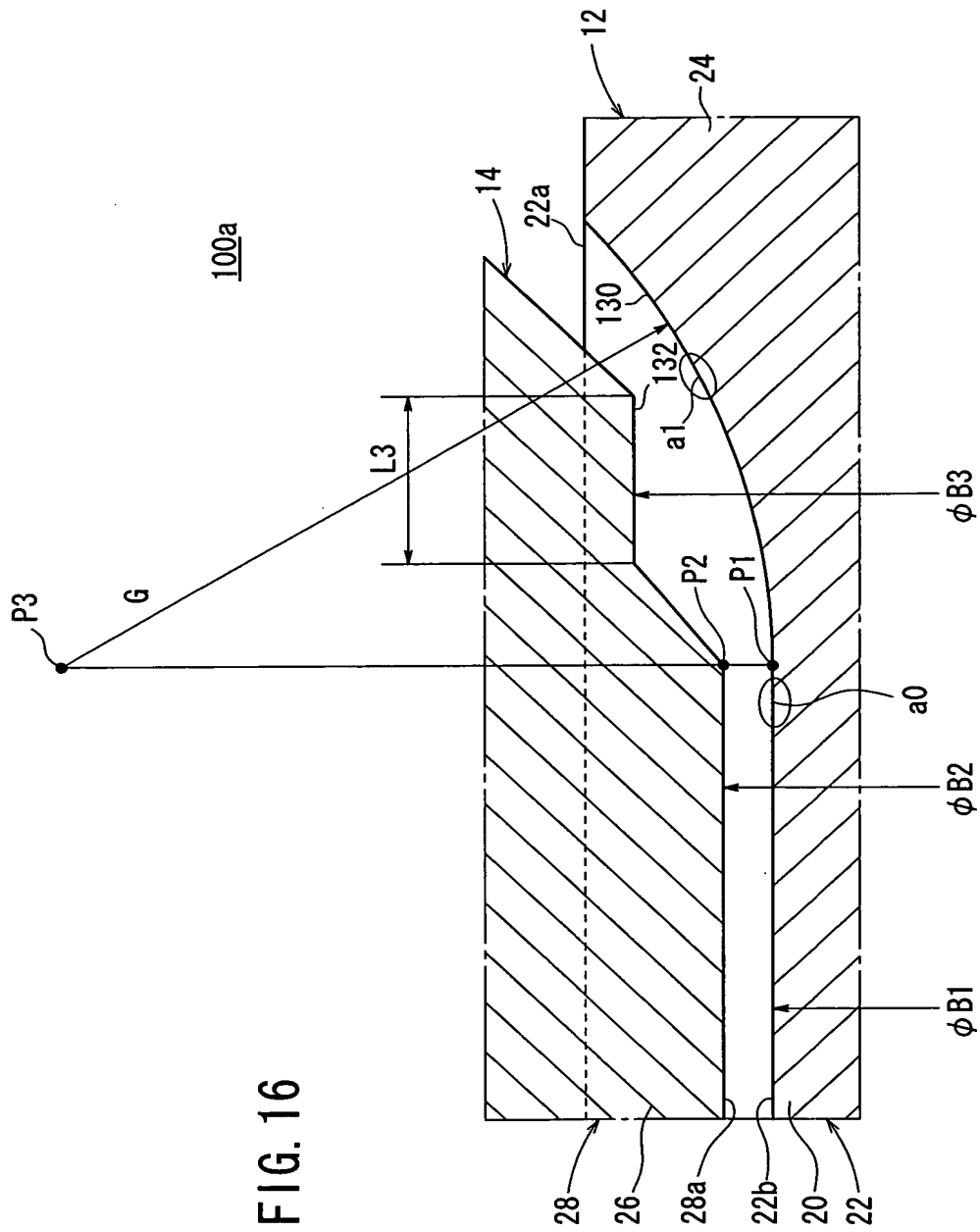


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FIG. 14



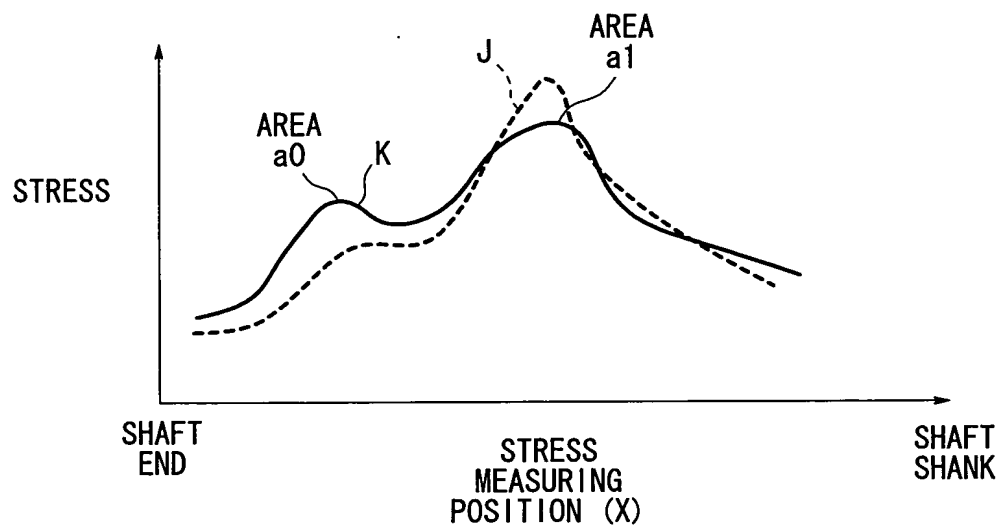






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FIG. 17



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FIG. 18

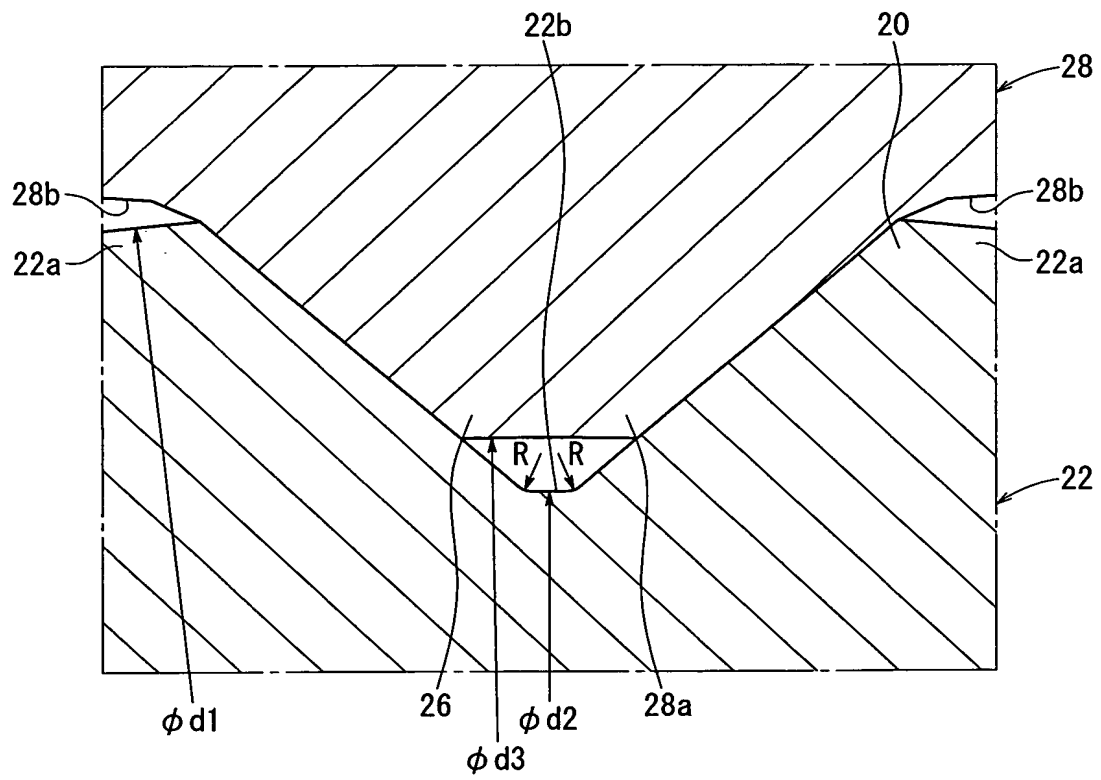
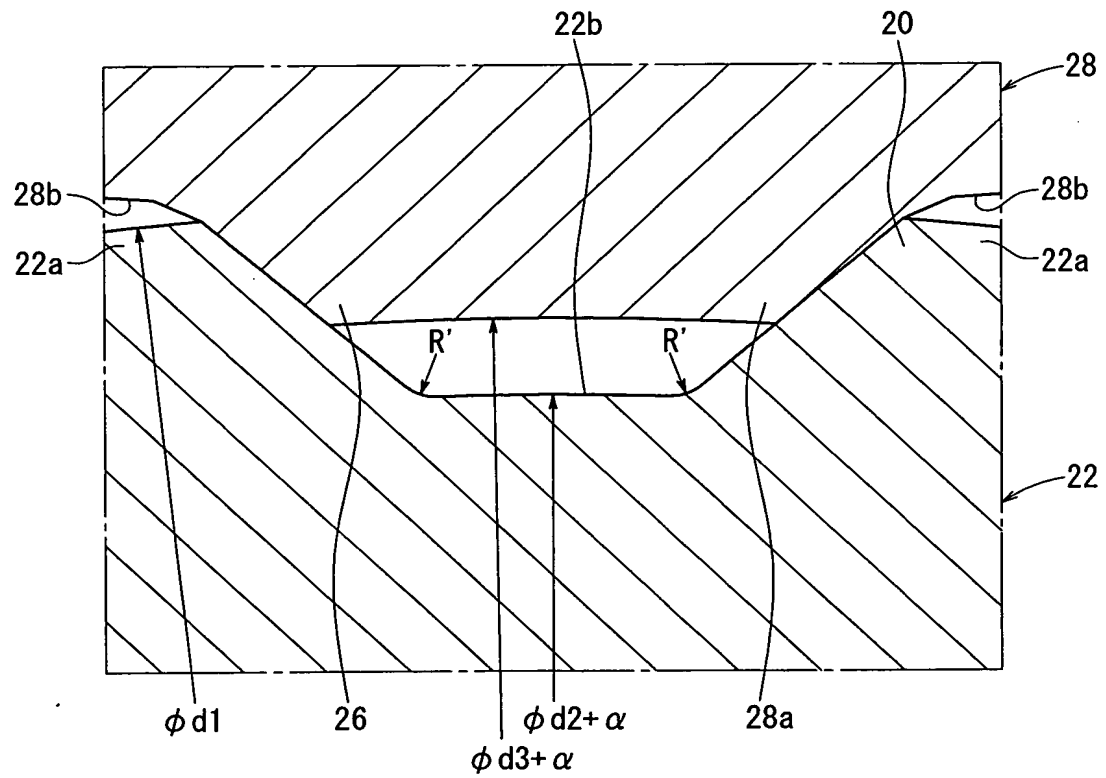


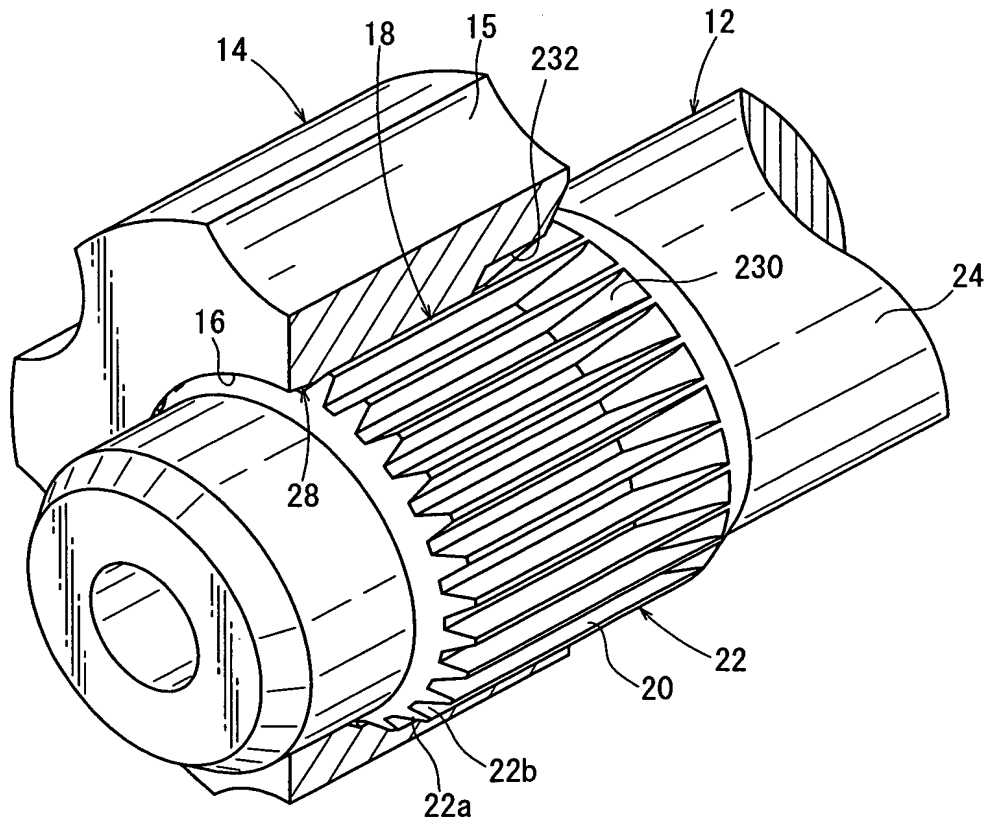
FIG. 19

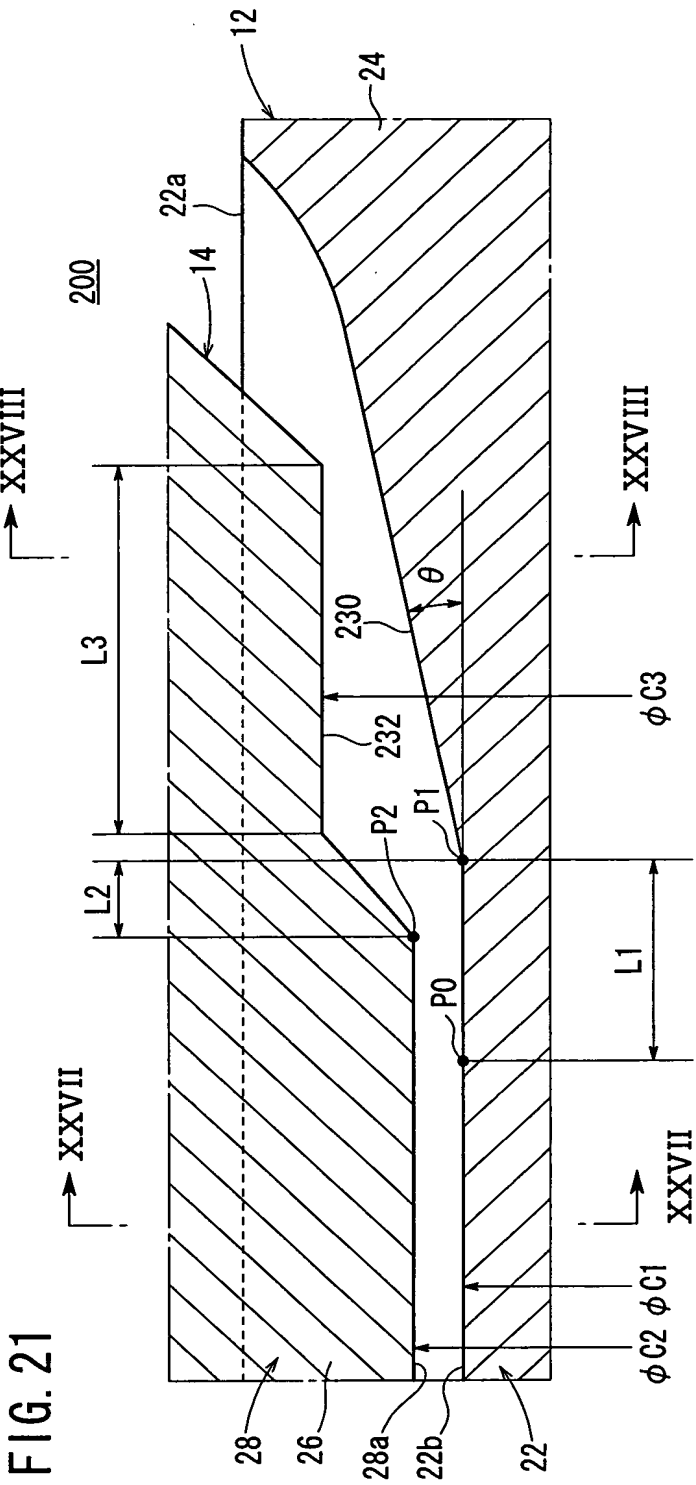


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FIG. 20

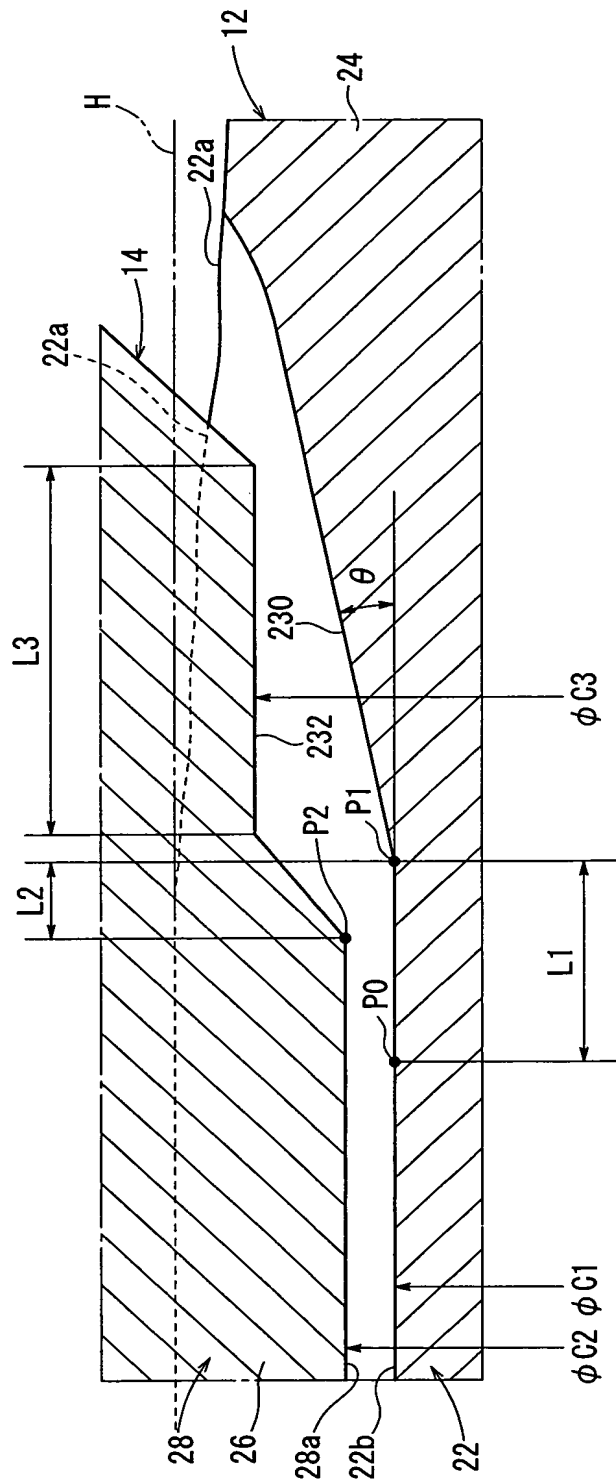
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FIG. 22



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FIG. 23

|                   | 2° | 4° | 6° | 8° | 10° | 15° | 30° | 45° | 65° | 90° |
|-------------------|----|----|----|----|-----|-----|-----|-----|-----|-----|
| STRESS RELAXATION | ×  | ×  | ○  | ○  | ◎   | ◎   | ◎   | ◎   | ○   | ×   |
| PRODUCTIVITY      | ◎  | ◎  | ◎  | ◎  | ◎   | ◎   | ◎   | ○   | ○   | ×   |

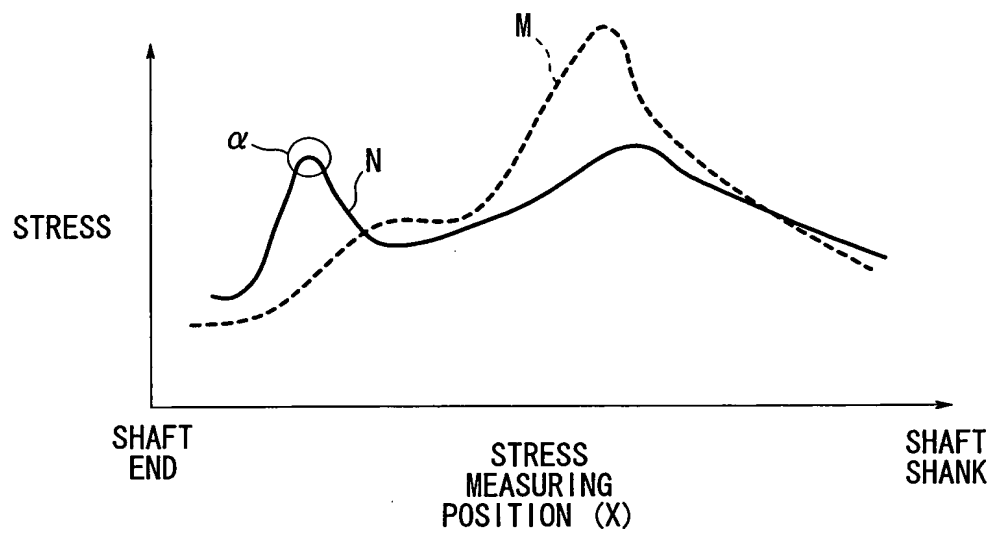
◎:VERY GOOD

○:GOOD

×:NOT GOOD

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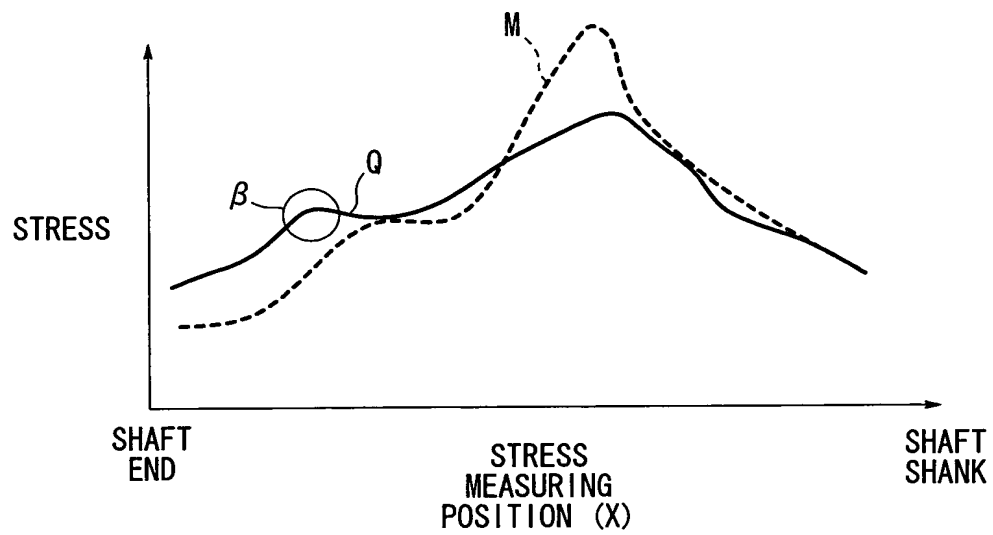
FIG. 24





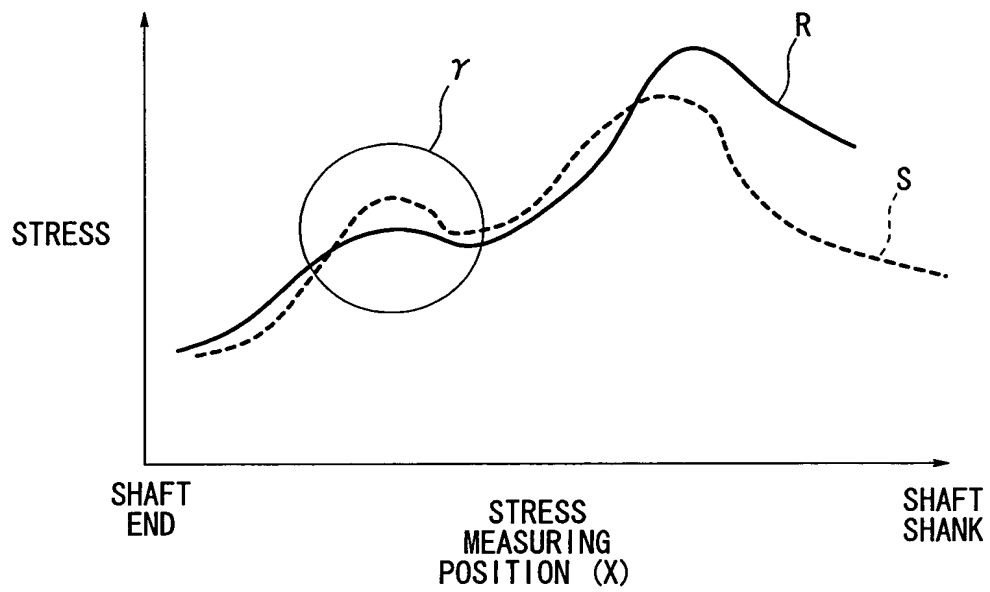
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FIG. 25



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FIG. 26



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FIG. 27

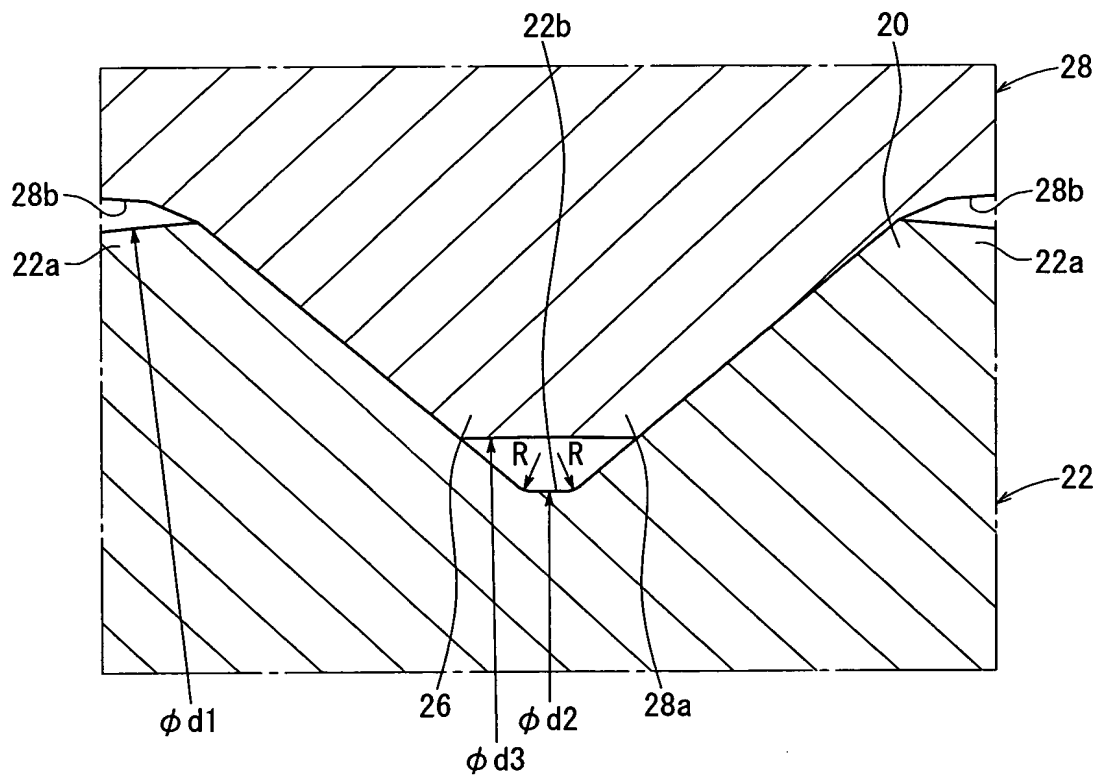


FIG. 28

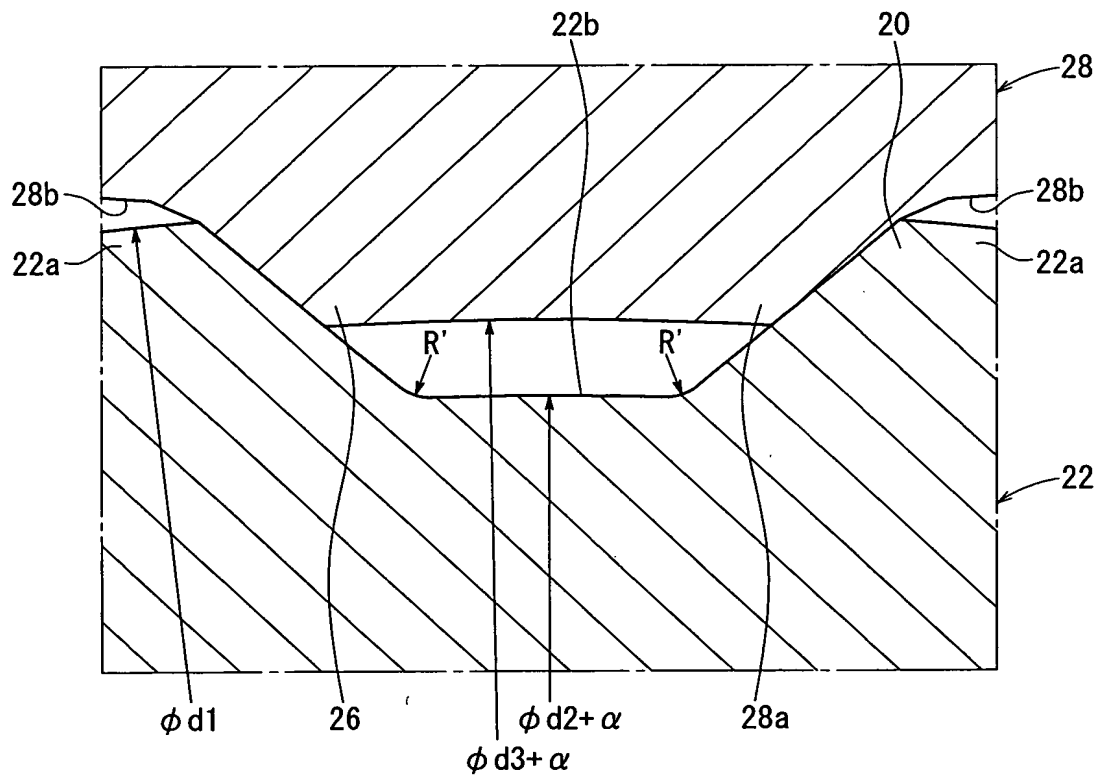


FIG. 29



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FIG. 31

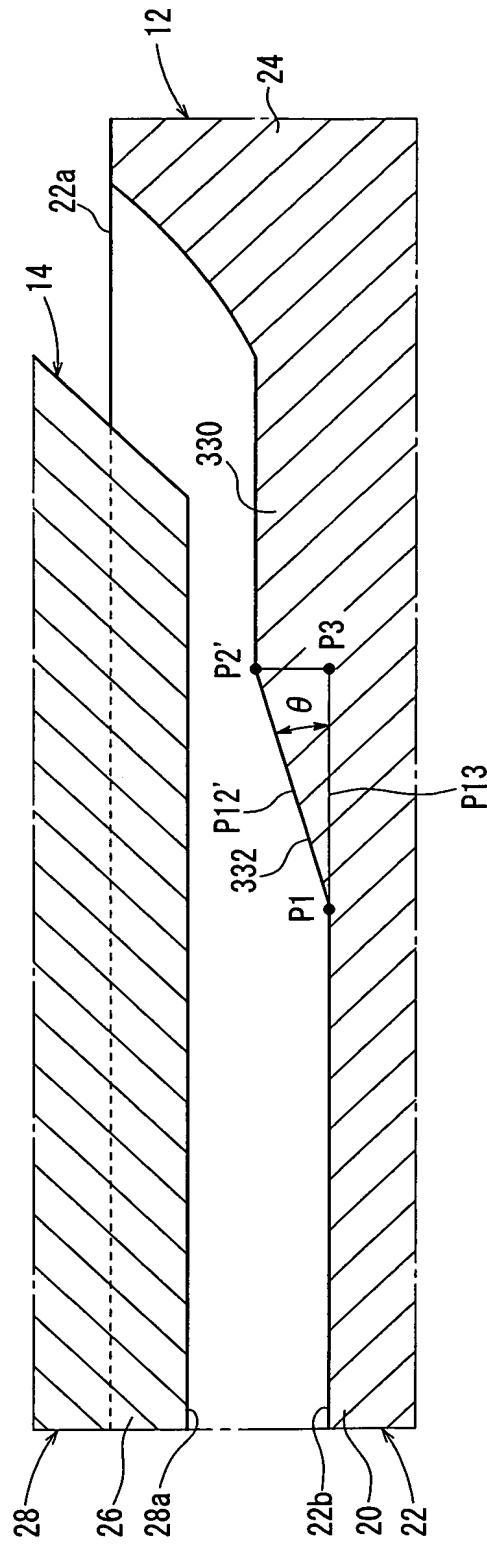
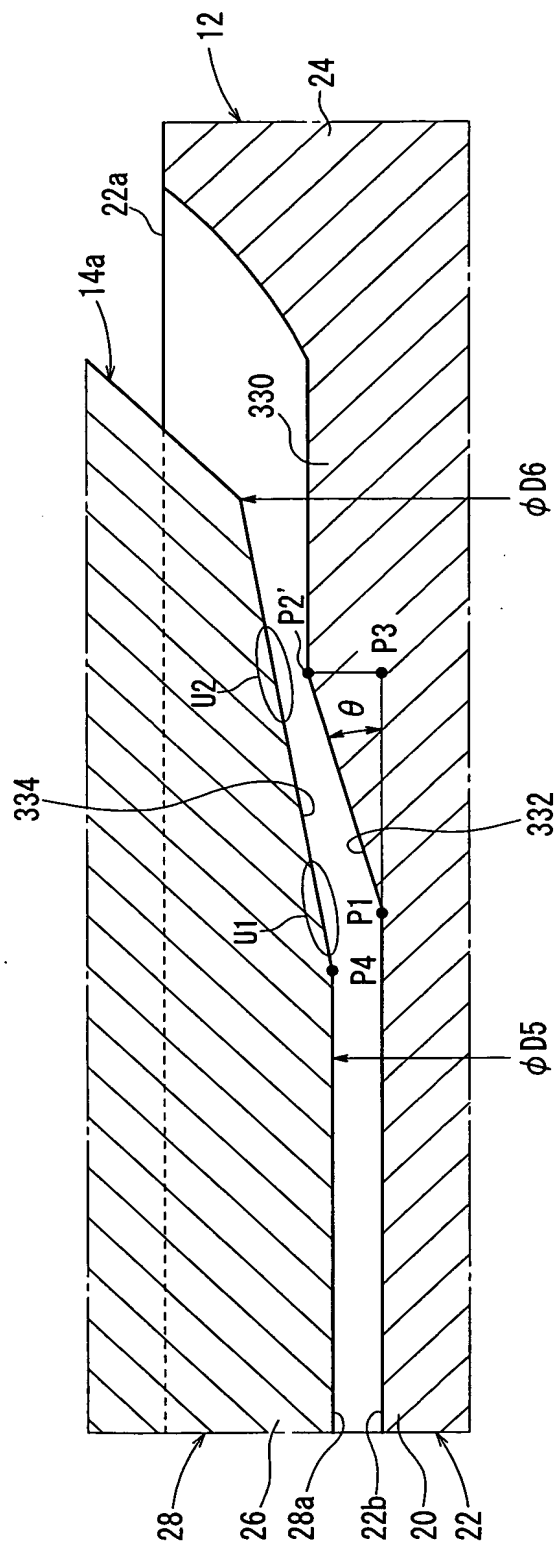


FIG. 32









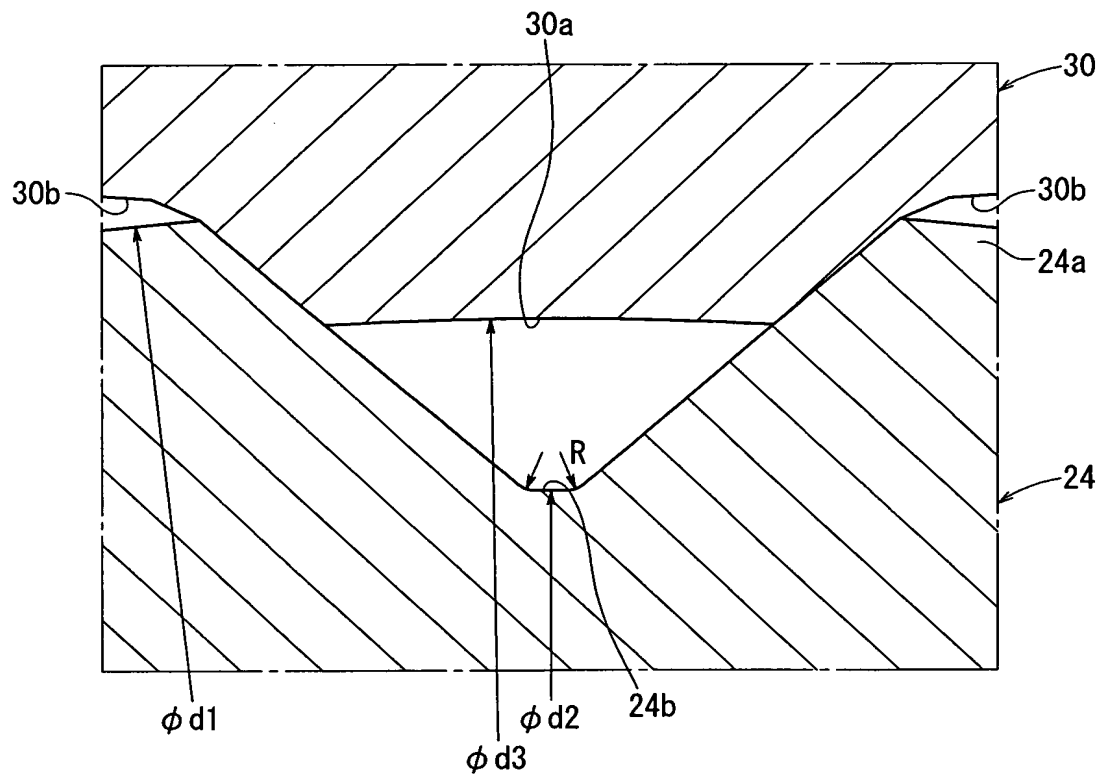
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FIG. 35

| TILT ANGLE $\theta$ | 3° | 5° | 10° | 15° | 25° | 35° | 45° | 90° |
|---------------------|----|----|-----|-----|-----|-----|-----|-----|
| STRESS RELAXATION   | ×  | ○  | ◎   | ◎   | ◎   | ◎   | ○   | ×   |
| PRODUCTIVITY        | ×  | ○  | ◎   | ◎   | ◎   | ◎   | ○   | ×   |

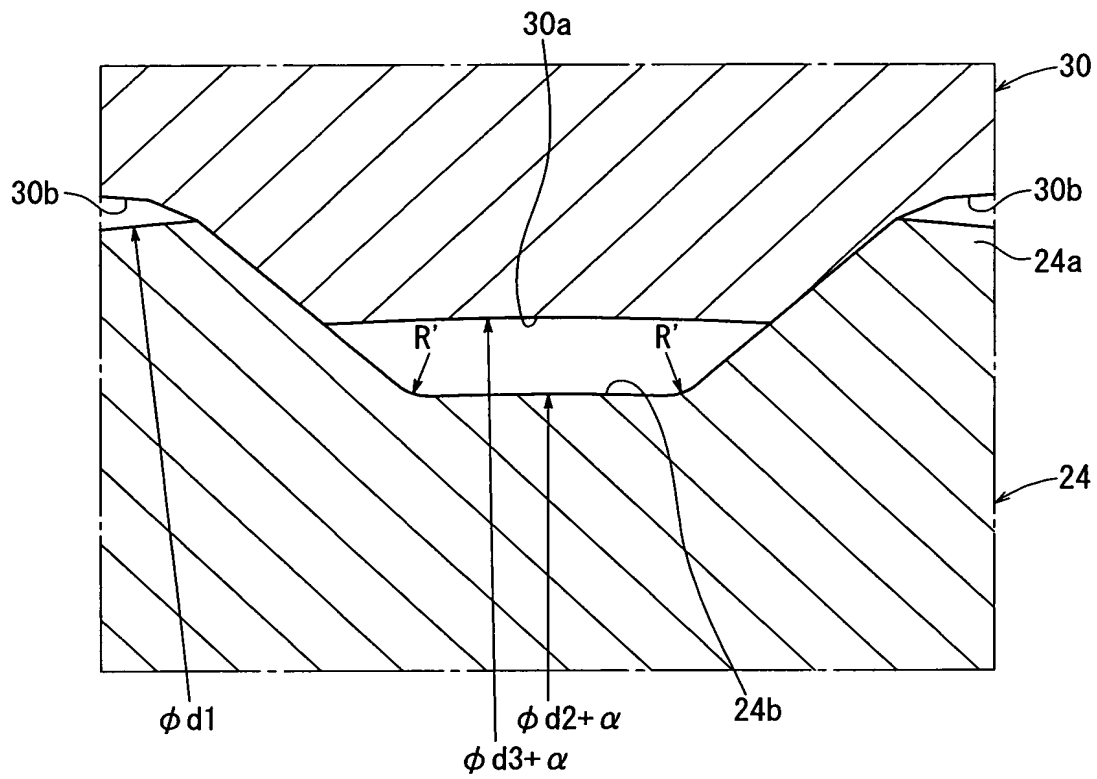
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FIG. 36



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FIG. 37



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FIG. 38

